

Date: Thursday, 02/04/2009 2:25:41 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: ARM	
Job Number	: 46844		Part Number	: D28441	
Estimate Number	: 11047		Drawing Number	: D2844 REV A	
P.O. Number	:		Project Number	: N/A	
This Issue	: 02/04/2009 S.O. No. :		Drawing Revision	: A	
Prsht Rev.	: NC		Material	:	
First Issue	: / /		Due Date	: 10/04/2009	
Previous Run	: 39542		Qty:	20	
Written By	:		Um:	Each	
Checked & Approved By	: <u>JUL 09 04 02</u>			30	
Comment	: Est: B 00.11.01 Removed P/O for Powder Coat - in house			processEC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0500W035	304 RD Tube .500 x .035W	59821.
		Comment: Qty.: 1.9941 f(s)/Unit Total : 39.8811 f(s)	
		304 RD Tube .500 x .035W	
		M304TR0500W035	
		9,9105	
		Punch 304/316 Seamless tubing with 2B finish, 1/2" OD x .035 Wall 21.49" long (Hole ctr. to hole ctr.) using Jig	44,8525
		DT 8012	
		Batch N111097 6X	25X *
2.0	BRAKE NC	NC BRAKE	30X
		Comment: BAND SAW	
		Form per Dwg D2844 using brake and bending Jig DT 8238-B	
		Deburr	Mr. 09/05/28
3.0	QC5	INSPECT WORK TO CURRENT STEP	counter S 09/05/29 x30
		Comment: INSPECT WORK TO CURRENT STEP	
4.0	POWDER COATING	POWDER COATING	30
		m 111472.	
		Comment: POWDER COATING	
		Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3	
		START TIME: 9:25	
		OVEN TEMPERATURE: 400°	
		FINISH TIME: 9:55	
			PL 09/06/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: ARM

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



30

JK 09-06-1

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6.0 QC6

DIMENSIONAL CHECK



counter
x30

Comment: DIMENSIONAL CHECK

ensure parts are still as per dwg D2844

7.0 PACKAGING 1

PACKAGING RESOURCE #1



3DX

Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 265

9141

SP
09/06/01

8.0 QC21

FINAL INSPECTION/W/O RELEASE



09/06/01

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-06-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

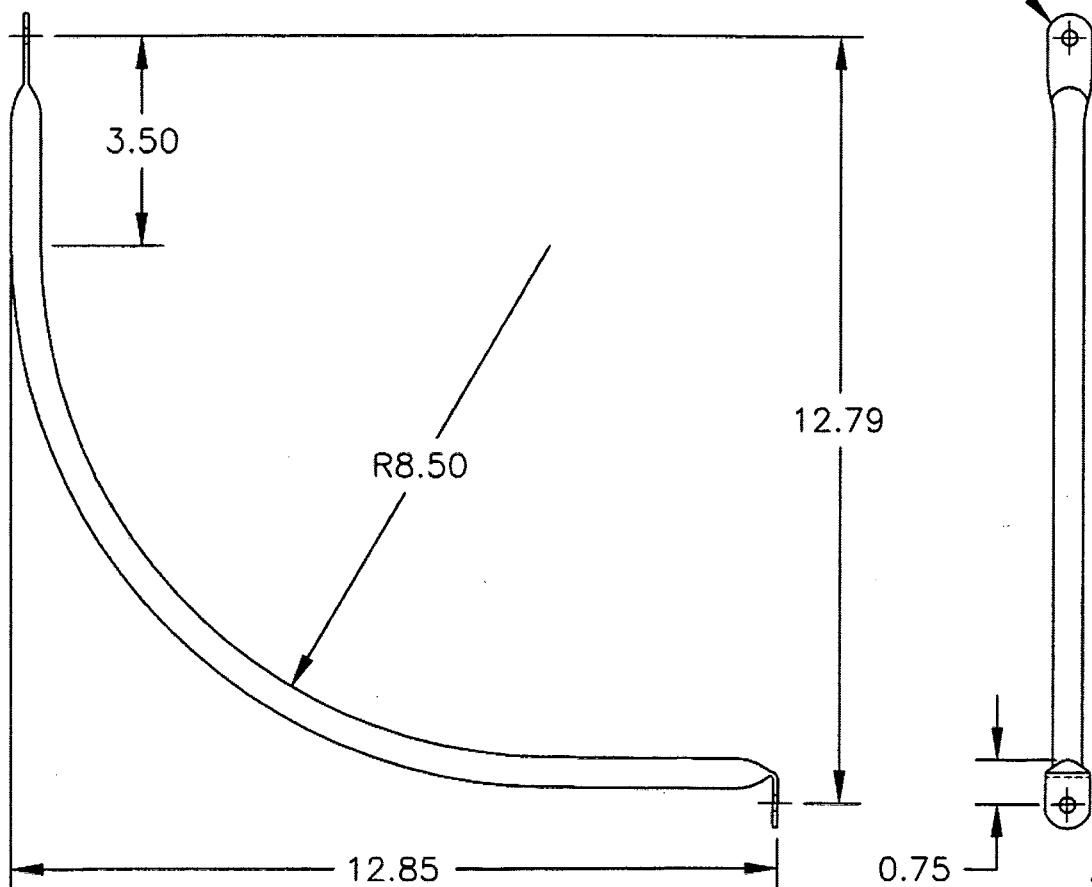
NOTE: Date & initial all entries

DART

DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>PAH</i>	APPROVED <i>S</i>	DRAWING NO. D2844	REV. A SHEET 1 OF 2
DATE 98.10.14		TITLE ARM	SCALE 1:3
A	98.10.14	NEW ISSUE	

RELEASED
98.10.11 *KE*

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



SHOP COPY
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SUBJECT TO AMENDMENT
WITHHOLD NOTICE
WORK CENTER
NO. *410844*

D2844-1

MATERIAL: AISI 304/316 SS TUBE, $\phi 0.50 \times 0.035$ WALL
ENSURE TUBE IS SEAMLESS

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

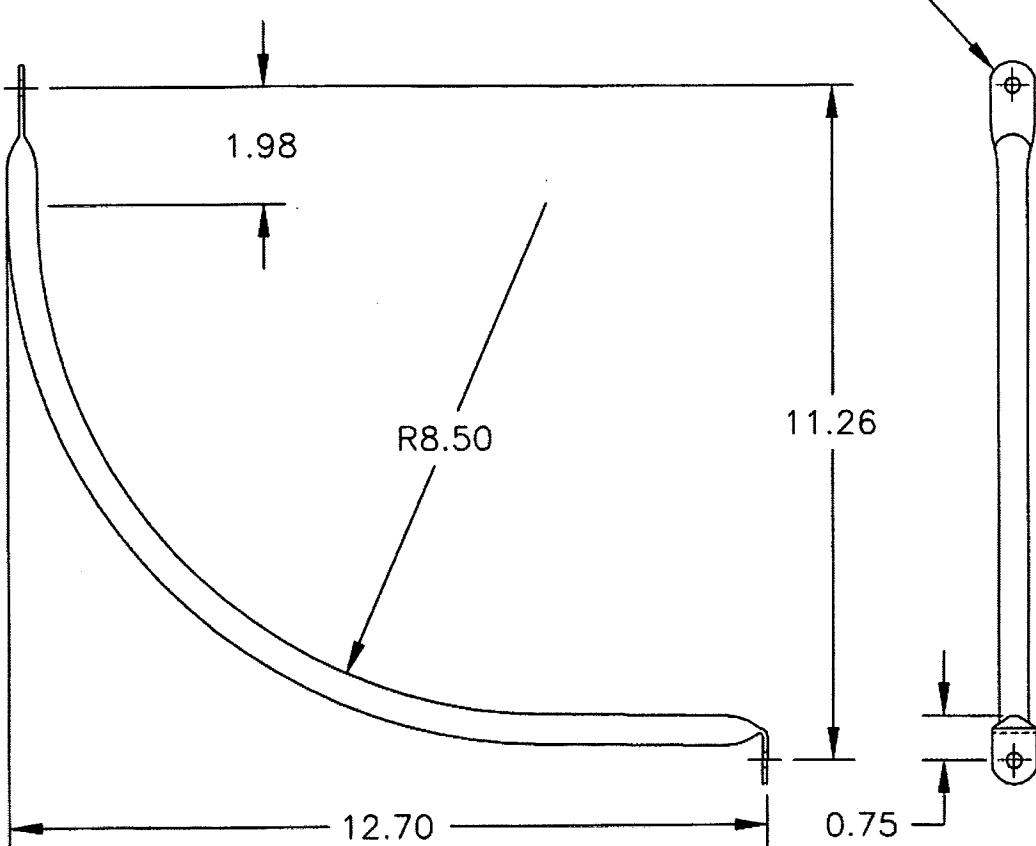
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

DART

DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED <i>DAH</i>	APPROVED <i>✓</i>	DRAWING NO. D2844
DATE 98.10.14		REV. A SHEET 2 OF 2 TITLE ARM SCALE 1:3

RELEASED
18.11.11 *KE*

PUNCH ENDS PER SPEC CONTROL DRAWING D2727

D2844-3

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK *110844*
NO *110844*

MATERIAL: AISI 304/316 SS TUBE, $\phi 0.50 \times 0.035$ WALL
ENSURE TUBE IS SEAMLESS

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3